

Date: Thursday, 30/10/2008 9:18:31 AM
 User: Melanie Fauteux

Process Sheet

DUPLICATE

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SQUARE TUBE
 Job Number : 41907
 Estimate Number : 13425
 P.O. Number :
 This Issue : 30/10/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 08/09/2008 Type : LARGE FAB ASSY
 Previous Run : 41789
 Part Number : PB6743001203
 Drawing Number : B6743001 P.17
 Project Number : N/A
 Drawing Revision : B1
 Material :
 Due Date : 26/09/2008
 Qty: 30 Um: 30
 Written By :
 Checked & Approved By : MF 08-10-30
 Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6TS1000W120 6061T6 SQ TUBE 1.00 x 1.00 X .120w



Comment: Qty.: 1.6844 f(s)/Unit Total: 15.1597 f(s)

6061T6 SQ TUBE 1.00 X 0.005 .120" *Handwritten: THIS W/O ONLY 1.03*

batch: M109928

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- cut to length as per dwg
- 2- make a 0.050" chamfer on both ends of tube
- 3- deburr

Handwritten: DIP 08/11/13

(21)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: Sostul24 (21)

4.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

- 1- drill holes as per dwg
- 2- make a 0.050" chamfer (100 degree) on both side of the 2 holes
- 3- deburr

Handwritten: DIP 08/11/13

(21)

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: Sostul24 (21)

Process Sheet

omer: CU-DAR001 Dart Helicopters Services

Drawing Name: SQUARE TUBE

Job Number: 41907

Part Number: PB6743001203

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 PB6743001227 Bushing



(12)

Comment: Qty.: 2.0000 Each(s)/Unit Total : 18.0000 Each(s)

Bushing

batch:

41916 → 16 ✓
B400273 → 8 ✓
41916 → 16 ✓
B400273 → 8 ✓

Pl 08.11.24

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



(12)

Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg

Pl 08.11.24

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



(12)

Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush

2- deburr

Pl 08.11.26

9.0 QC10 VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/11/26 (12)

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sosulubas (12)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



(2x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 438

8/11/26

SO

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/26

Job Completion



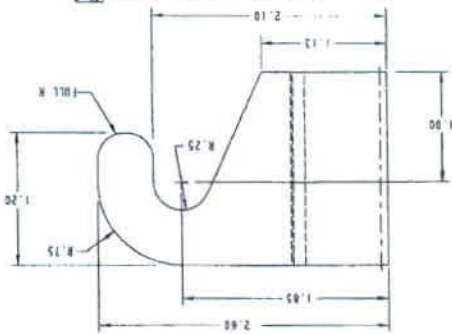
mf 08-11-26



ORIGINAL

PREMIER AVIATION, INC.
1000 AVIATION PARKWAY, CHANDLER, ARIZONA 85226
DLSUVB B67-43001
REV. 1.0
DATE 11-83

②
-213 FLANGED HOOK
MATERIAL: 6061-T6 ALUMINUM
SCALE: 2.000



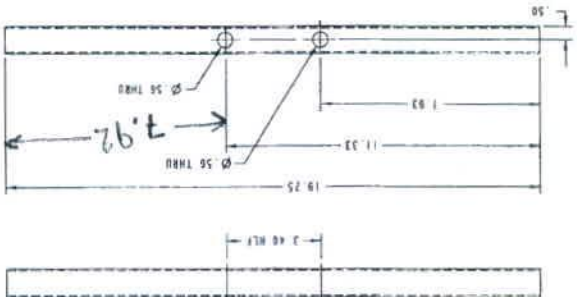
②
-211 SQUARE TUBE
MATERIAL: 1.00 50 X .063 WALL, 6061-T6
SCALE: 1.000



②
-209 SQUARE TUBE
MATERIAL: 1.00 50 X .063 WALL, 6061-T6
SCALE: 1.000

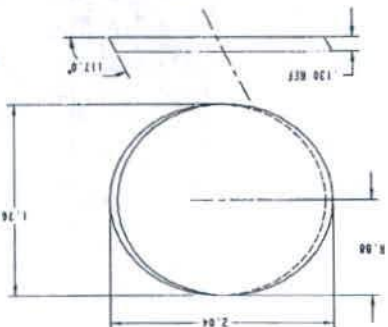


②
-203 SQUARE TUBE
MATERIAL: 1.00 50 X .063 WALL, 6061-T6
SCALE: 0.500

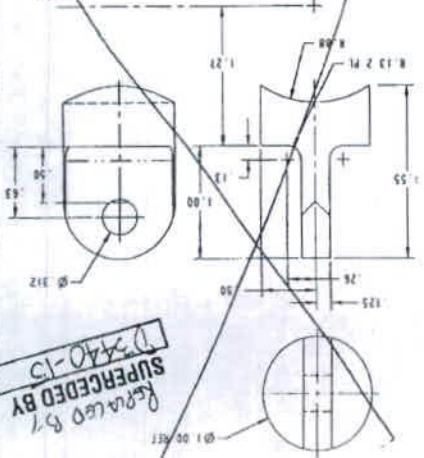


RELEASED
#0001.20

②
-199 OUTER TUBE END CAP
MATERIAL: 1.00 50 X .063 WALL, 6061-T6
SCALE: 2.000



①
-215 CONTOURED MALE EYE
MATERIAL: 1.00 50 X .063 WALL, 6061-T6
SCALE: 2.000



REWORKED BY
03440-15

Work Order:	41907
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Description: Square Tube

Part Number:	PB6743001203
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Inspection Dwg: , Rev: B1

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/>	First Article	<input checked="" type="checkbox"/>	Prototype
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[illegible]

Measured by: DJP

Date: 08/01/19

Audited by:

Date: 05/04/20

Prototype Approval:

Date: 1/19

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

